

# APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 04039

SHEET 1 OF 1

DWG NO. 646.9700

REV: B

PREPARED  
BY

D. PETERS

DATE: 08/09/13

EFFECT ON DWG  
☒ INC. ☐ UNINC.

DWG TITLE: CUTTER SUB ASSY

APPROVED BY:

ENGR

MFG

QC

EFF:

NEXT ORDER

TRANSACTION CODES (TC):  
A-ADD C-CREATE  
R-REVISE D-DELETE

REASON: MARKED INSPECTION DIMENSIONS

ECR:

NONE

Superceded

DOCUMENTS EFFECTED:

☐ RFMS ☐ MDL ☐ INSTALL INSTRU ☐ ICA ☐ BOM

CHANGE CATEGORY  
☐ MAJOR ☒ MINOR

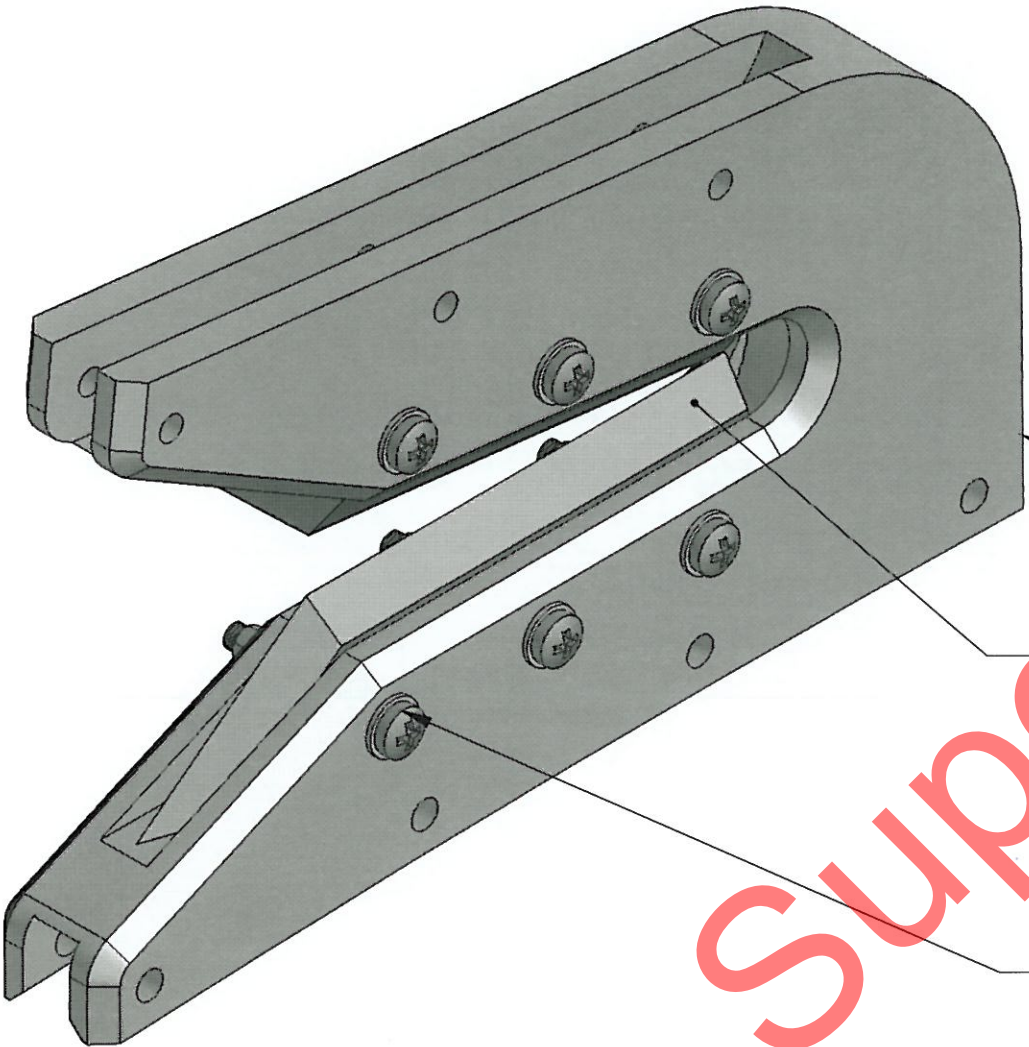
DER REVIEW REQUIRED  
☐ YES ☒ NO

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| REVISIONS |                                      |          |          |
|-----------|--------------------------------------|----------|----------|
| REV.      | DESCRIPTION                          | DATE     | APPROVED |
|           | LAST PROTOTYPE REVISION: PR2         |          | N/C      |
| N/C       | INITIAL RELEASE                      | 05/29/09 | P. BRAVO |
| A         | INCORPORATED ECN 02744, 03838, 03912 | 06/06/13 | P. BRAVO |
| B         | INCORPORATED ECN 03967               | 07/03/13 | P. BRAVO |
| C         | INCORPORATED ECN 04039               | 08/09/13 | P. BRAVO |










NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; PRETREAT PRC-DESOTO PR-148 ADHESION PROMOTER; PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
- 3 MATERIAL: AISI A2 TOOL STEEL  
CONDITION: ANNEALED  
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- 4 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
- 5 DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
- 6 IDENTIFY IAW MPP-120
- 7 APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2 UPON ASSEMBLY
- 8 CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE
- 9 ALL DIMENSIONS NOT SPECIFIED ARE CONTROLLED BY 646.9710.

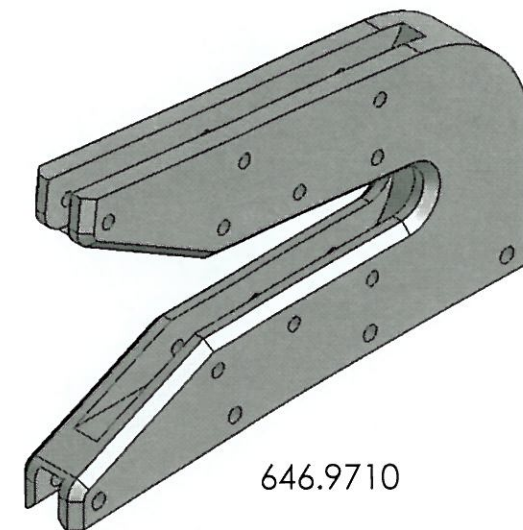
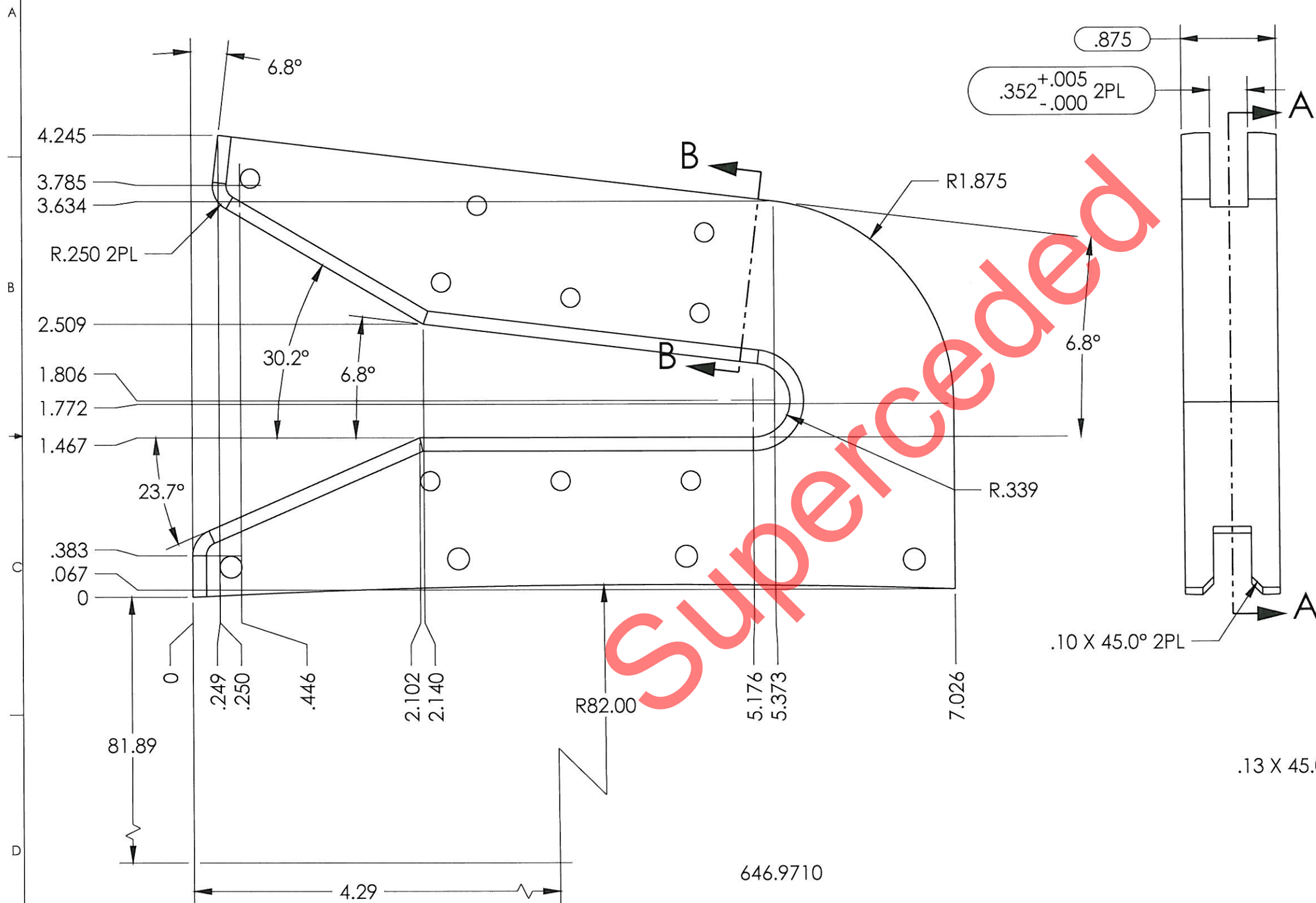


646.9701  
or  
646.9702

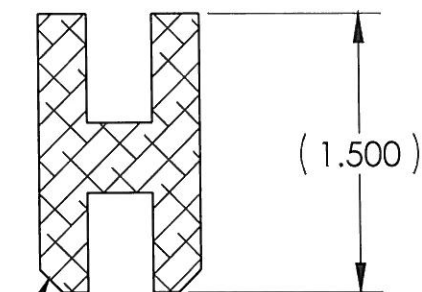
- 3 6PL  
4 12PL  
6 6PL

|   |      |  |                    |   |   |   |
|---|------|--|--------------------|---|---|---|
| 1   |      | 7  | 646.9712           | BODY (U CHANNEL)  |  |   |
| 6   | 6    | 6  | 601.1541           | LOCKNUT   | MS21042L08  |   |
| A/R   | A/R  | 5  | 601.2764           | RTV, LOCTITE 598  |   |   |
| 12  | 12   | 4  | 601.2764           | WASHER  | NAS1149FN832P   |   |
| 6   | 6    | 3  | 601.2765           | SCREW   | MS27039-0819  |   |
| 2   | 2    | 2  | 646.9711           | BLADE   |  |    |
|   | 1    | 1  | 646.9710           | BODY  |  |    |
|  |      |  | 646.9702           | CUTTER SUB ASSY (U CHANNEL)   |   |   |
|  |      |  | 646.9701           | CUTTER SUB ASSY   |   |   |
| 9702  | 9701 | FIND #   | PART #             | DESCRIPTION   | MAT'L   | SPEC.   |
| QTY   |      | PARTS LIST   |                    |   |   |   |
| NEXT ASSY (S)   |      | ORIGINAL DATE<br>(MO-DA-YR) 05-29-09   |                    | APICAL INDUSTRIES<br>2608 TEMPLE HEIGHTS DR.<br>OCEANSIDE, CA. 92056-3512 (760)724-5300 |   |   |
| 646.9600  |      | DRAWN BY<br>R. ROSANO  |                    |   |   |   |
|   |      | CHECKER<br>P. BRAVO  |                    |   |   |   |
|   |      | DRAWING APPROVAL<br>P. BRAVO<br>05-29-09   |                    |   |   |   |
|   |      | CONTRACT No.   |                    | CUTTER SUB ASSY   |   |   |
|   |      | UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES<br>TOLERANCES ARE:<br>2 PLACE DECIMALS ± .01<br>3 PLACE DECIMALS ± .005<br>ANGLES ± .5° |                    |   |   |   |
|   |      | SIZE<br>B  | CAGE CODE<br>07MZ6 | DWG. NO.<br>646.9700  | REV.<br>C   |   |
|   |      |  |                    | SCALE NONE  | SHEET 1 OF 6  |   |

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3  
B4



.13 X 45.0° TYP.

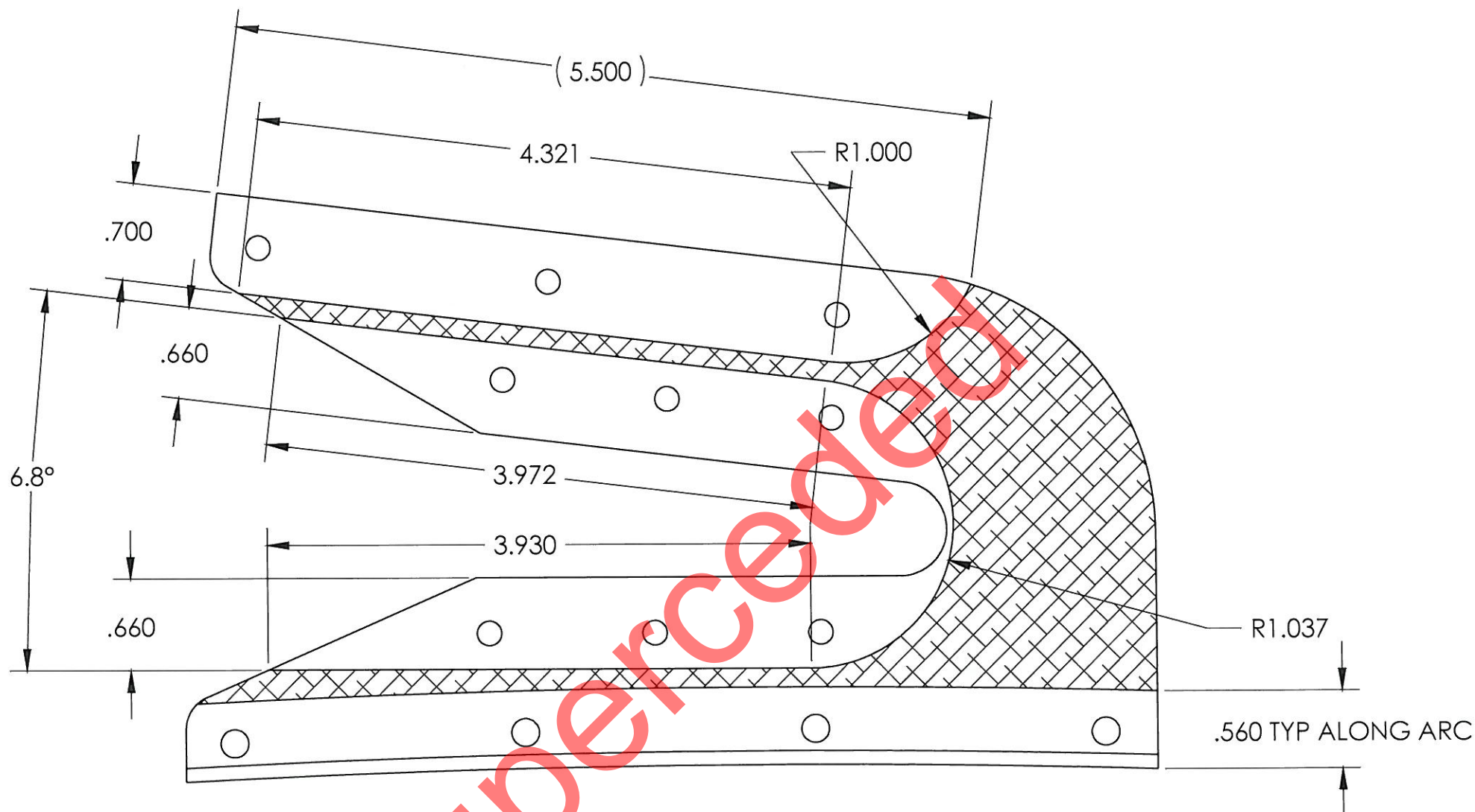
SECTION B-B

|   |                     |  |                      |
|---|---------------------|--|----------------------|
| ORIGINAL DATE<br>(MO-DA-YR) 05-29-09  |                     | APICAL INDUSTRIES  |                      |
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| DRAWING APPROVAL<br>P. BRAVO  |                     | CUTTER SUB ASSY  |                      |
| CONTRACT No.  |                     |  |                      |
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|   |                     | CAGE CODE<br>07M26   | DWG. NO.<br>646.9700 |
|   |                     | SCALE: NONE  |                      |
|   |                     | SHEET 2 OF 6   |                      |



1 2 3 4 5 6 7 8

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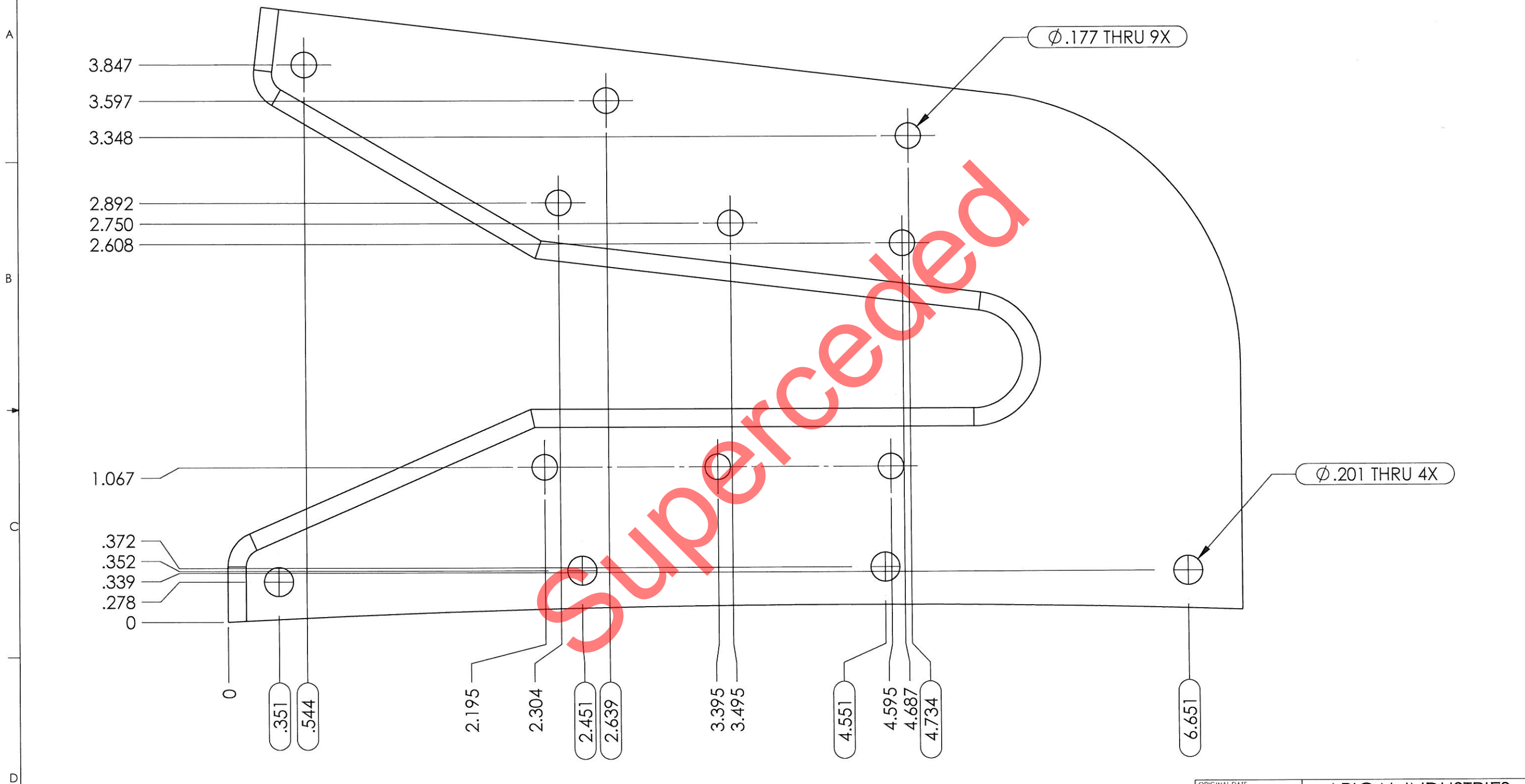


SECTION A-A  $\frac{2}{C6}$

646.9710

|   |                     |   |                      |
|---|---------------------|---|----------------------|
| ORIGINAL DATE<br>(MO. DA. YR) 05-29-09  |                     | APICAL INDUSTRIES<br>2608 TEMPLE HEIGHTS DR.<br>OCEANSIDE, CA. 92056-3512 (760)724-5300 |                      |
| DRAWN BY<br>R. ROSANO   | CHECKER<br>P. BRAVO |   |                      |
| DRAWING APPROVAL<br>P. BRAVO<br>05-22-09  |                     | CUTTER SUB ASSY   |                      |
| CONTRACT No.  |                     |   |                      |
| UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES<br>TOLERANCES ARE:<br>2 PLACE DECIMALS $\pm .01$<br>3 PLACE DECIMALS $\pm .005$<br>ANGLES $\pm .5^\circ$ |                     | SIZE<br>B   | REV.<br>C            |
|   |                     | CAGE CODE<br>07MZ6  | DWG. NO.<br>646.9700 |
|   |                     | SCALE NONE SHEET 3 OF 6   |                      |

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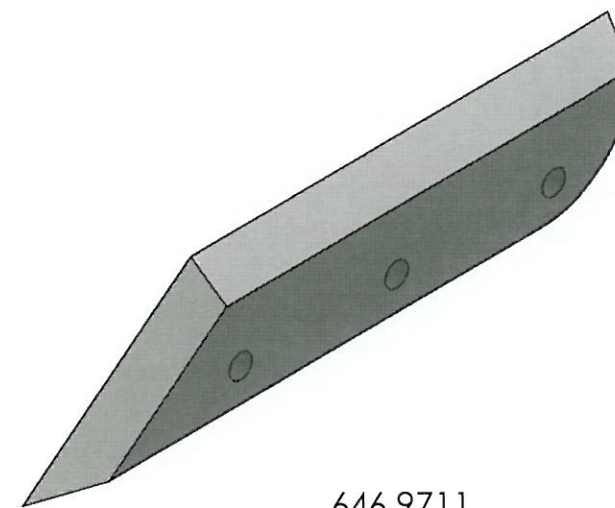
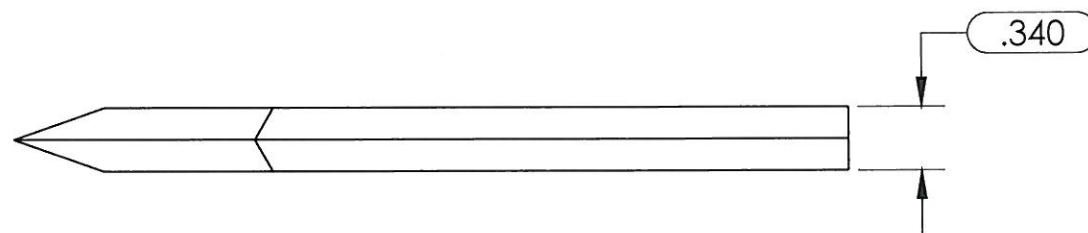


HOLE LOCATIONS +/- .002

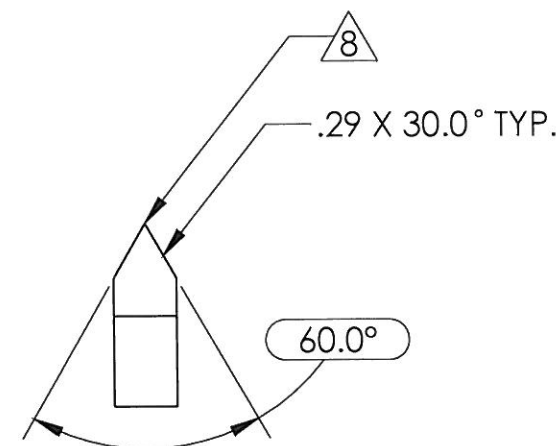
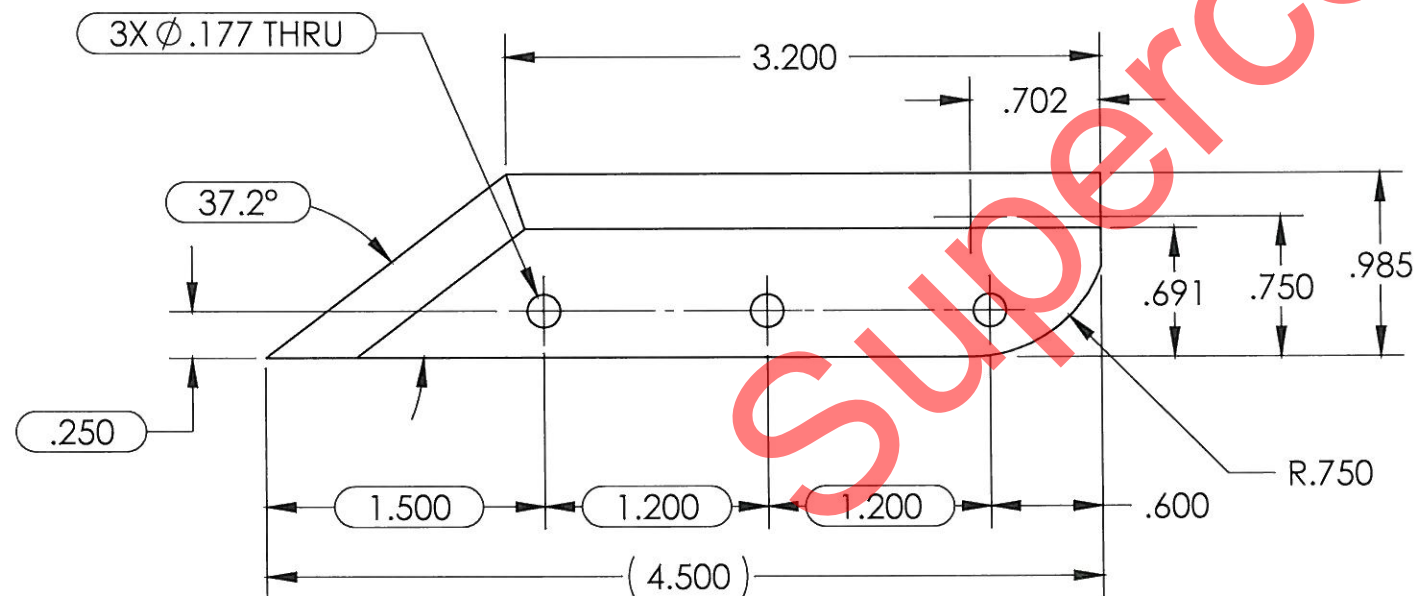
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| DRAWN BY<br>R. ROSANO  | CHECKER<br>P. BRAVO |   |                      |
| DRAWING APPROVAL<br>P. BRAVO<br>05-29-09   |                     | CUTTER SUB ASSY   |                      |
| CONTRACT No.   |                     |   |                      |
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|  |                     | CAGE CODE<br>07MZ6  | DWG. NO.<br>646.9700 |
|  |                     | SCALE<br>NONE   | SHEET<br>4 OF 6      |

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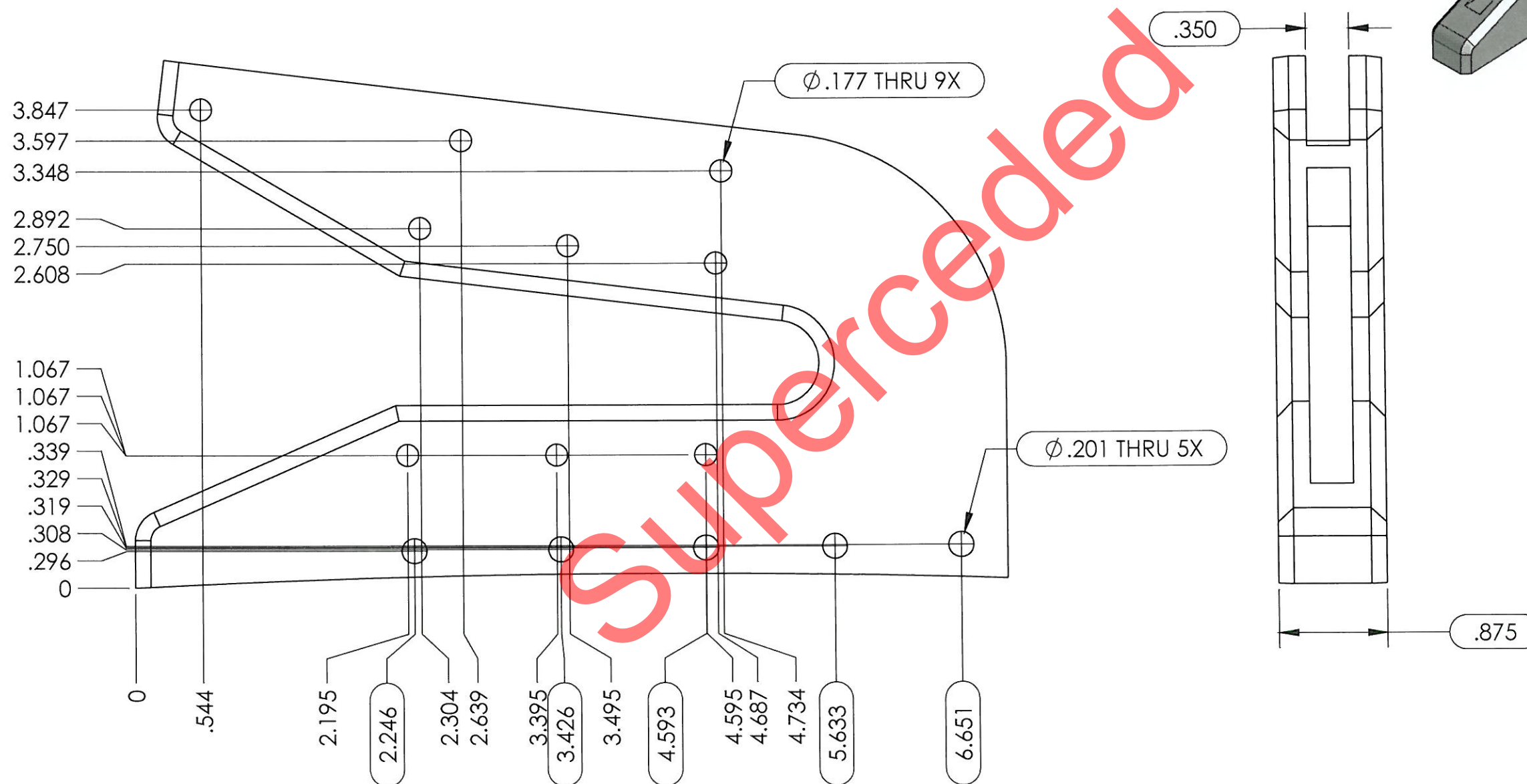


646.9711

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| DRAWING APPROVAL<br>P. BRAVO   |                     | CUTTER SUB ASSY  |                      |
| CONTRACT No.   |                     |  |                      |
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|  |                     | CAGE CODE<br>07MZ6   | DWG. NO.<br>646.9700 |
|  |                     | SCALE<br>NONE  | SHEET<br>5 OF 6      |



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646.9712

|  |                     |   |                      |
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| DRAWN BY<br>R. ROSANO  | CHECKER<br>P. BRAVO |   |                      |
| DRAWING APPROVAL<br>P. BRAVO 05-29-09  |                     | CUTTER SUB ASSY   |                      |
| CONTRACT No.   |                     |   |                      |
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|  |                     | CAGE CODE<br>07MZ6  | DWG. NO.<br>646.9700 |
| SCALE NONE   |                     | SHEET 6 OF 6  |                      |